



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 171665-A



Part No: D350-591-312

Job Qty: 1 ea

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/12/18

Job Tracking No:

Due Date: 2/16/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
220	Powdercoat	1 pcs		2/15/18	0.00	0.30	Powdercoat1		mt 18/03/12
230	HandFinish	1 pcs		2/16/18	0.00	0.19	HandFinish3		BFB 08/03-12
240	QC	1 pcs		2/16/18	0.00	0.00	QC3		38
250	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging1-3		9-89
260	QC	1 pcs		2/16/18	0.00	0.00	QC4		Smb
265	DC	1 pcs		2/16/18	0.00	0.00	DC		
270	Packaging	1 pcs		2/16/18	0.00	0.00	Packaging3-1		Smb
280	QC21-FG	1 Ea		2/16/18	0.00	0.00	QC21		APR 13 2018

Part Op 220 - START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____
 Descriptions: 265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001
 270 - Identify and pack for shipping as per PPPD350-591-312 Location : FG072

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-35A	Bolt	2 Ea (2 ea)	250-Packaging	5017089
AN4-13A	Bolt	8 Ea (8 ea)	250-Packaging	5027022
AN5-36A	Bolt	2 Ea (2 ea)	250-Packaging	5014151
D2230-3	Mounting Lug	4 Ea (4 ea)	250-Packaging	5049159
D2618	Bushing	2 Ea (2 ea)	250-Packaging	5043411
D2856-400-720	Abrasion Strip 4" X 7.20"	2 Ea (2 ea)	250-Packaging	5037226
D3235-1	Mounting Lug	2 Ea (2 ea)	250-Packaging	5049111
D3278-041	Support Assembly	1 Ea (1 ea)	250-Packaging	5048828
MS21042L3	Nut	2 Ea (2 ea)	250-Packaging	5038764
MS21042L4	Nut	8 Ea (8 ea)	250-Packaging	5045901
MS21042L5	Nut	2 Ea (2 ea)	250-Packaging	5016880
NAS1149D0363J	Washer	4 Ea (4 ea)	250-Packaging	5015269
NAS1149D0463J	Washer	16 Ea (16 ea)	250-Packaging	5027136
NAS1149D0563J	Washer	4 Ea (4 ea)	250-Packaging	5025143

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
250-Packaging	AN3-35A	2	294	0
	AN4-13A	8	807	0
	AN5-36A	2	270	0
	D2230-3	4	107	0
	D2618	2	488	0
	D2856-400-720	2	177	0
	D3235-1	2	88	0
	D3278-041	1	18	0
	MS21042L3	2	3,144	0
	MS21042L4	8	3,511	0
	MS21042L5	2	823	0
	NAS1149D0363J	4	3,299	0
	NAS1149D0463J	16	4,644	0
	NAS1149D0563J	4	2,238	0
Part Specifications				
Specifications could not be found.				

Plex 3/12/18 10:22 AM Dart.Gagnon.Michelle



Container No: S050076



Part: D350-591-312

Job No: 171665-A

Serial No/Batch: S043820

Revision:

Inspector:

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Date: 03/12/18



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Canada

Tel (613) 632-5200

D350-591-312
Job Sheet 171665



Part No: D350-591-312

Job Qty: ~~10 ea~~ *9 units*

Part Name: Heli-Access-Step™ RH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/7/18

Job Tracking No:

Due Date: 2/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3572-1 JLM IPP Rev:C 08-04-02 ECN1163 DD verified by:EC IPP Rev:D 08-04-08 ECN1164 DD verified by:eC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		2/14/18	0.00	0.00	Start Up Large Fab-4		<i>SL 2/23/18</i>
110	Large Fab	10 pcs		2/15/18	0.00	10.00	Large Fab 2		<i>SL 2/23/18</i>
120	QC	10 pcs		2/15/18	0.00	0.00	QC9		<i>PD 18-2-23</i>
130	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>PD 18-2-23</i>
140	HandFinish	10 pcs		2/15/18	0.00	1.87	HandFinish1		<i>18-02-23</i>
150	QC	10 pcs		2/15/18	0.00	0.00	QC7-2		<i>PD 18-2-26</i>
180	Large Fab	10 pcs		2/15/18	0.00	10.00	Large Fab 2		<i>SL</i>
190	QC	10 pcs		2/15/18	0.00	0.00	QC10		<i>SL</i>
200	QC	10 pcs		2/15/18	0.00	0.00	QC5		<i>SL</i>
210	HandFinish	10 pcs		2/15/18	0.00	1.87	HandFinish1		<i>18-03-02</i>
220	Powdercoat	10 pcs		2/15/18	0.00	2.98	Powdercoat1		<i>SL 18-3-07</i>
230	HandFinish	10 pcs		2/16/18	0.00	1.87	HandFinish3		<i>BEBAS 3-07</i>
240	QC	10 pcs		2/16/18	0.00	0.00	QC3		<i>11 MAR 12 2018</i>
250	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging1-3		<i>9-89</i>
260	QC	10 pcs		2/16/18	0.00	0.00	QC4		
265	DC	10 pcs		2/16/18	0.00	0.00	DC		
270	Packaging	10 pcs		2/16/18	0.00	0.00	Packaging3-1		
280	QC21-FG	10 Ea		2/16/18	0.00	0.00	QC21		

Part Op 110 - 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig DT10115, weld Fwd End Plate as per QSI 004 & Descriptions: Dwg D3272 A/R Aluminum Rod *M138763* 3-Grind End Plate flush

180 - 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod *M138763* 6-Grind End Plate flush 7-Install last rivet as per Dwg.

220 - START TIME: *10:15am* OVEN TEMPERATURE: *320F* FINISH TIME: *10:45am*

265 - Photocopy bluefile and type labels as per PPP D350-591-312 CHG001

270 - Identify and pack for shipping as per PPPD350-591-312 Location :FG072

5013 80

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 Ea (1 ea)	90-Start up Operation	
D3219-1	Plate	20 Ea (2 ea)	90-Start up Operation	
D3272-1	Step	10 Ea (1 ea)	90-Start up Operation	
D3065-041	Step Leg Assembly	10 Ea (1 ea)	180-Large Fab	



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Container View (Active) - Master Unit Containers

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
001390	S047804	AN3-35A	Bolt	s017089	ST348	20
001390	S047801	AN4-13A	Bolt	s027722	ST344	80
001390	S047800	AN5-36A	Bolt	s014157	ST336	20
001390	S049426	D2230-3	Mounting Lug	s049159	ST521	20
001390	S049435	D3235-1	Mounting Lug	s049171	ST522	20
001390	S049425	D3278-041	Support Assembly	s048828	ST522	10
001390	S047778	MS21042L3	Nut	S038764	ST303	20
001390	S047777	MS21042L4	Nut	S045901	ST303	80
001390	S047776	MS21042L5	Nut	S016880	ST303	20
001390	S047743	NAS1149D0363J	Washer	S015269	ST263	40
001390	S047742	NAS1149D0463J	Washer	S027736	ST263	160
001390	S047735	NAS1149D0563J	Washer	S025743	ST263	40

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

D2230-3 420

Plex 3/8/18 3:07 PM dart.quirion.sonia